

Work Order ID 115975

Friday, April 04, 2014 1:59:51 PM

115975

Page 1

Item ID: D4030-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Long Basket Assembly (350)

Stop

NS2

Start Date: 4/30/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/30/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-04-10

Tooling:

Date:

Run Start

NR1

QC: _____ Date: _____

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4030	D

100	Pick Kit	0.00
-----	----------	------

100

Packaging

Memo

0.00

Packaging

DAS
32
9-89

4/10/12 (1)

110	Assemble as per dwg	0.00
-----	---------------------	------

110

HandFinish

Memo

0.00

Hand Finishing

1 x d MLJ 4/6/13

120	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------

120

QC

Memo

0.00

Quality Control

DAS
27
9-89

4/5/14

Work Order ID 115975

Friday, April 04, 2014 1:59:51 PM

115975

Page 2

Item ID: D4030-041

Revision ID:

Item Name: Long Basket Assembly (350)

Start Date: 4/30/14 Start Qty: 1.00 *1*

Required Date: 4/30/14 Req'd Qty: 1.00 *1*

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

PP 115633

0.00

DAS
06
9-89

MAY 14 2014

Packaging

Memo

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

0.00

QC

Memo

Quality Control

14/5/15

MRF
14-5-15

Friday, April 04, 2014 1:59:50 PM

115975

D4030-041

Required Date: 4/30/14

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC , IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-1239 EC verified by:JLM ,

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2530		Manufactured	No			100	Each	9.0000	1	1			
D2530									**				
Handle Weldment													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST255				9					
				100754				6					
				110029				3					
D2535		Manufactured	No			100	Each	99.0000	2	2			
D2535									**				
Spring													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST011				99					
				100552				49					
				110374				50					
D2537		Manufactured	No			100	Each	151.0000	2	2			
D2537									**				
Bushing													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST011				151					
				103608				7					
				103861				42					
				110274				24					
				112958				40					
				113174				38					

Picklist Print

Friday, April 04, 2014 1:59:50 PM

Page 2

Work Order ID: 115975

115975

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/30/14

Required Date: 4/30/14

Start Qty: 1.00

Required Qty: 1.00

D3913-041 Manufactured No

100

Each

0.0000

1

1

D3913-041

Long Basket Base Assembly, 350

**

115717 (11) 11/10/14

D3914-041 Manufactured No

100

Each

0.0000

1

1

D3914-041

Long Basket Lid Assembly (350)

**

115672 (11) 11/10/14

D3917-3 Manufactured No

100

Each

109.0000

6

6

D3917-3

Washer

**

115050 14/10/14
DAS 32 9-89

Location

Loc Qty

Loc Code

ST070

109

104859

71

109114

38

104859 54

D3953-3 Manufactured No

100

Each

61.0000

2

2

D3953-3

Gas Spring Stud, Lid

**

DAS 32 9-89

Location

Loc Qty

Loc Code

ST075

61

112504

37

112745

24

112504

D3953-7 Manufactured No

100

Each

75.0000

2

2

D3953-7

Spring Spacer

**

DAS 32 14/10/14 (1)
9-89

Location

Loc Qty

Loc Code

ST075

75

102928

17

105465

11

109115

47

109115

Friday, April 04, 2014 1:59:50 PM

Shop Packet Print

Page 2

Picklist Print

Friday, April 04, 2014 1:59:50 PM

Page 3

Work Order ID: 115975

115975

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/30/14

Required Date: 4/30/14

Start Qty: 1.00

Required Qty: 1.00

D3953-9

Manufactured No

100

Each

61.0000

2

2

D3953-9

Gas Spring Washer

DAS
32
9-89

Location

Loc Qty

Loc Code

ST075

37

107922

17

112486

18

94719

2

ST076

24

113774

12

113775

12

112486

D3953-17

Manufactured No

100

Each

11.0000

2

2

D3953-17

Gas Spring Spacer

DAS
32
9-89

111481

Location

Loc Qty

Loc Code

ST076

11

106073

11

D3953-19

Manufactured No

100

Each

28.0000

1

1

D3953-19

Gas Spring Bracket

DAS
32
9-89

Location

Loc Qty

Loc Code

ST076

28

104984

18

107604

10

114984

D3953-21

Manufactured No

100

Each

18.0000

1

1

D3953-21

Gas Spring Bracket

DAS
32
9-89

11/10/12 (1)

Location

Loc Qty

Loc Code

ST076

18

107641

18

107641

Friday, April 04, 2014 1:59:50 PM

Shop Packet Print

Page 3

Picklist Print

Friday, April 04, 2014 1:59:50 PM

Page 4

Work Order ID: 115975

115975

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/30/14

Required Date: 4/30/14

Start Qty: 1.00

Required Qty: 1.00

D3969-3 Manufactured No

100 Each 54.0000 1 1

DAS
32
9-89

D3969-3

Gas Spring

Location

Loc Qty

Loc Code

ST262

54

100611

18

110088

8

114957

18

99623

10

100611

AN3-14A

Purchased No

100 Each 183.0000 4 4

DAS
32
9-89

AN3-14A

Bolt

Location

Loc Qty

Loc Code

ST351

108

m127044

58

m128429

50

ST511

75

m127815

75

m128429

AN3-16A

Purchased No

100 Each 125.0000 2 2

DAS
32
9-89

AN3-16A

Bolt

m128429

14/2/12 (1)

Location

Loc Qty

Loc Code

GA

44

117441

44

ST352

31

M126192

31

ST511

50

M127070

50

Picklist Print

Friday, April 04, 2014 1:59:50 PM

Page 5

Work Order ID: 115975

115975

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/30/14

Required Date: 4/30/14

Start Qty: 1.00

Required Qty: 1.00

AN5-17A

Purchased

No

100

Each

390.0000

4

4

AN5-17A

Bolt

**

M128578

DAS
32
9-89

Location

Loc Qty

Loc Code

GA

36

117872

36

ST337

150

m128403

150

st503

150

125388

150

ST514

54

m126176

54

AN4-12

Purchased

No

100

Each

116.0000

3

3

AN4-12

Bolt

**

DAS
32
9-89

Location

Loc Qty

Loc Code

ST356

116

m125709

16

m127817

50

m128403

50

AN310-4

Purchased

No

100

Each

207.0000

3

3

AN310-4

Nut

**

M128818

DAS
32
9-89

Location

Loc Qty

Loc Code

ST342

207

M126872

7

M127815

25

M128429

25

M128650

150

Friday, April 04, 2014 1:59:50 PM

Shop Packet Print

Page 5

Picklist Print

Friday, April 04, 2014 1:59:50 PM

Page 6

Work Order ID: 115975

115975

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/30/14

Required Date: 4/30/14

Start Qty: 1.00

Required Qty: 1.00

AN310C4

Purchased

No

100

Each

177.0000

2

2

AN310C4

Nut

DAS
32
9-89

Location

Loc Qty

Loc Code

ST342

177

M125952

27

M127817

50

M128429

13

M128489

33

M128537

4

M128739

50

m/28489

MS21042L3

Purchased

No

100

Each

3,010.000

6

6

MS21042L3

Nut

DAS
32
9-89

Location

Loc Qty

Loc Code

ST314

2055

M127410

1014

M127831

41

M128401

1000

ST506

955

123900

955

m/28401

MS21042L5

Purchased

No

100

Each

702.0000

4

4

MS21042L5

Nut

DAS
32
9-89
14/0/12-1

Location

Loc Qty

Loc Code

GA

5

117611

5

ST315

197

m127304

197

ST509

500

m127813

500

Friday, April 04, 2014 1:59:50 PM

Shop Packet Print

Page 6

Picklist Print

Friday, April 04, 2014 1:59:50 PM

Page 7

Work Order ID: 115975

115975

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/30/14

Required Date: 4/30/14

Start Qty: 1.00

Required Qty: 1.00

MS24665-151

Purchased

No

100

Each

474.0000

3

3

MS24665-151

Cotter Pin

DAS
32
9-89

Location

Loc Qty

Loc Code

GA

29

17566

29

ST323

445

125646

2

m127305

43

m128401

400

M128901

MS24665-300

Purchased

No

100

Each

66.0000

2

2

MS24665-300

COTTER PIN

DAS
32
9-89

Location

Loc Qty

Loc Code

GA

30

118234

30

ST299

36

124555

36

NAS1149F0432P

Purchased

No

100

Each

2,980.000

6

6

NAS1149F0432P

WASHER

DAS
32
9-89
14/0/12(1)

Location

Loc Qty

Loc Code

ST295

2923

125268

32

M127813

3

M128429

2000

M128591

888

ST510a

57

M126221

57

M128091

Friday, April 04, 2014 1:59:50 PM

Shop Packet Print

Page 7

Picklist Print

Friday, April 04, 2014 1:59:50 PM

Page 8

Work Order ID: 115975

115975

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/30/14

Required Date: 4/30/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0563P

Purchased

No

100

Each

407.0000

4

4

DAS
32
9.89

NAS1149F0563P

Washer

Location

Loc Qty

Loc Code

ST295

407

121350

407

m121350

NAS1149F0332P

Purchased

No

100

Each

7,230.000

8

8

DAS
32
9.89

NAS1149F0332P

Washer

Location

Loc Qty

Loc Code

GA

205

122063

205

ST295

2558

123900

12

m123185

46

m128401

2500

ST510a

4421

125646

1921

m127831

2500

ST522

46

m123185

46

14/5/12(1)

m128646

Picklist Print

Friday, April 04, 2014 1:59:50 PM

Page 9

Work Order ID: 115975

115975

Parent Item: D4030-041

D4030-041

Parent Item Name: Long Basket Assembly (350)

Start Date: 4/30/14

Required Date: 4/30/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0432R

Purchased

No

100

Each

4,198.000

2

2

NAS1149C0432R

WASHER

DAS
32
9-89

14/04/12(1)

Location

Loc Qty

Loc Code

GA

1719

m125807

1719

ST292

88

119124

6

121255

3

122441

79

ST510a

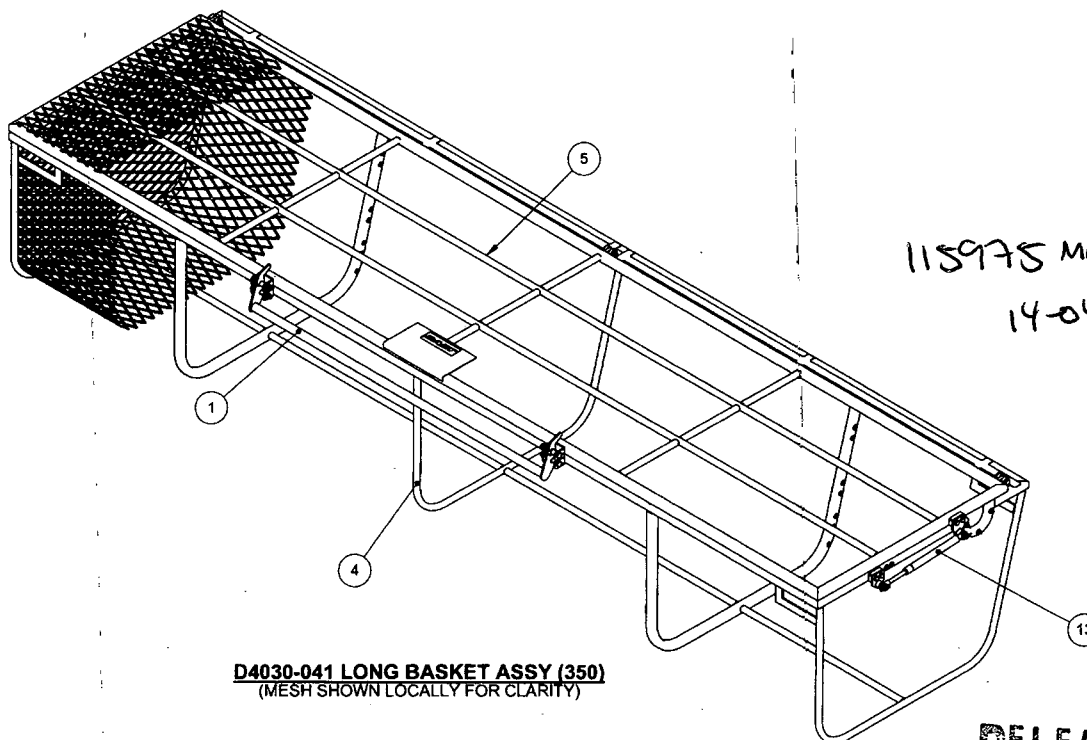
2391

m126221

2391

m126221

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4030-041	LONG BASKET ASSY (350)
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	D3914-041	LONG BASKET LID ASSY (350)
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	4	AN3-14A	BOLT, MACHINE
15	2	AN3-16A	BOLT, MACHINE
16	3	AN4-12	BOLT, MACHINE
17	4	AN5-17A	BOLT, MACHINE
18	2	AN310C4	NUT, PLAIN, CASTELLATED
19	3	AN310-4	NUT, PLAIN, CASTELLATED
20	6	MS21042L3	NUT, SELF-LOCKING
21	4	MS21042L5	NUT, SELF-LOCKING
22	2	MS24665-300	COTTER PIN
23	3	MS24665-151	COTTER PIN
24	2	NAS1149C0432R	WASHER
25	6	NAS1149F0432P	WASHER
26	8	NAS1149F0332P	WASHER
27	4	NAS1149F0563P	WASHER

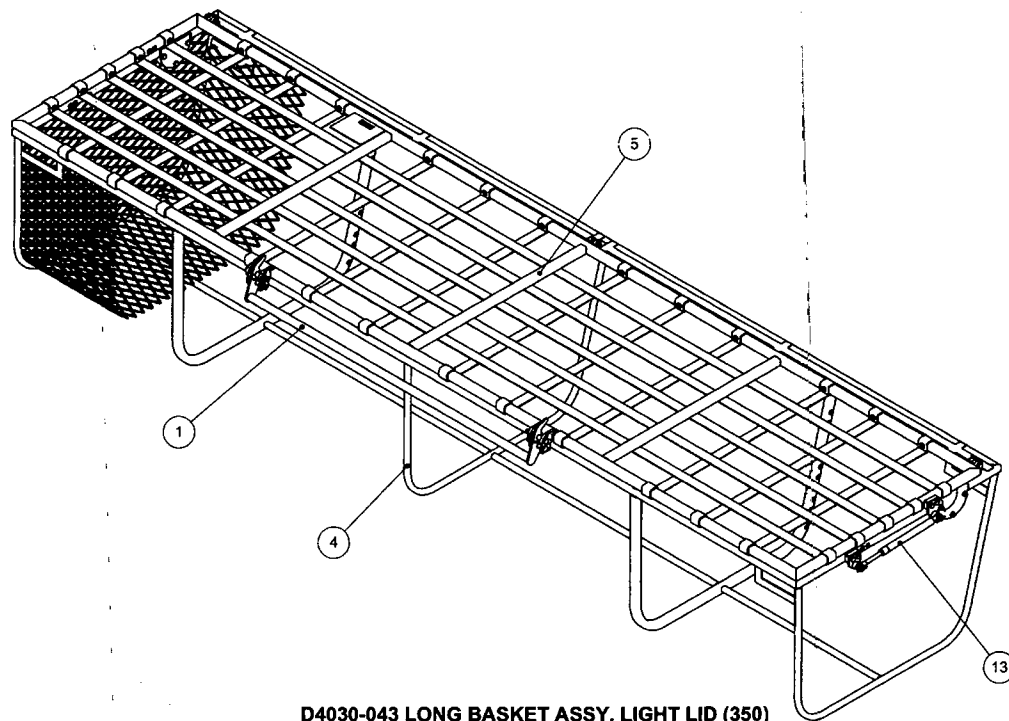


D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: N/A
 7) WEIGHT: 72 lbs APPROX

D	REFORMAT FOR CLARITY. PICTORIAL UPDATE TO MULTIPLE VIEWS DUE TO CHANGES IN SUB ASSEMBLIES.	AJS	13.07.18
C	QTY FOR ITEMS #30 & #31 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D8-1). ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	CP	DRAWING NO.	REV. D
MFG. APPR.	MB	D4030	SHEET 1 OF 4
APPROVED	MB	TITLE	SCALE
DE APPR.	MB	LONG BASKET ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	D3915-041	LIGHT LID ASSY, LONG BASKET
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14	4	AN3-14A	BOLT
15	2	AN3-20A	BOLT
16	3	AN4-12	BOLT
17	2	AN5-17A	BOLT
18	2	AN5-21A	BOLT
19	3	AN310-4	NUT, PLAIN, CASTELLATED
20	2	AN310C4	NUT, PLAIN, CASTELLATED
21	6	MS21042L3	NUT, SELF-LOCKING
22	4	MS21042L5	NUT, SELF-LOCKING
23	3	MS24665-151	COTTER PIN
24	2	MS24665-300	COTTER PIN
25	6	NAS1149F0432P	WASHER
26	4	NAS1149F0563P	WASHER
27	8	NAS1149F0332P	WASHER
28	2	NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

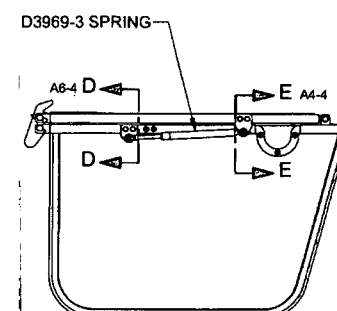
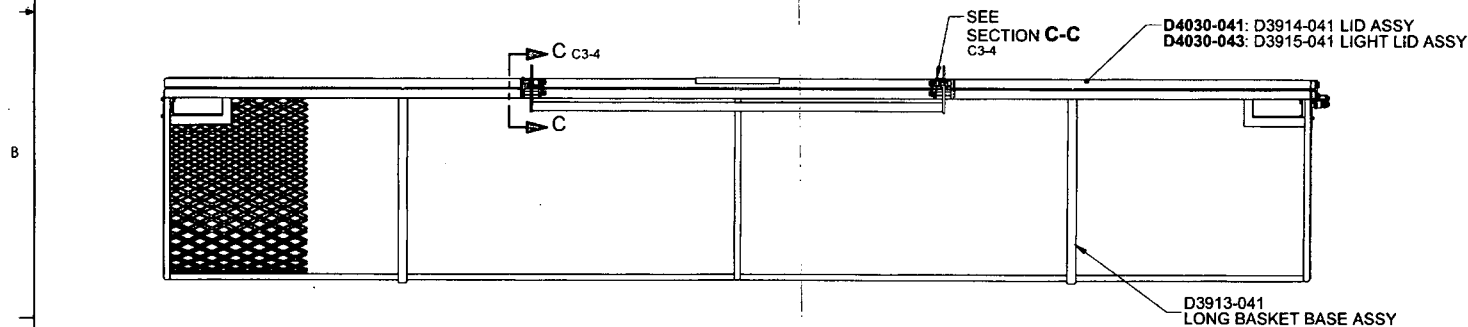
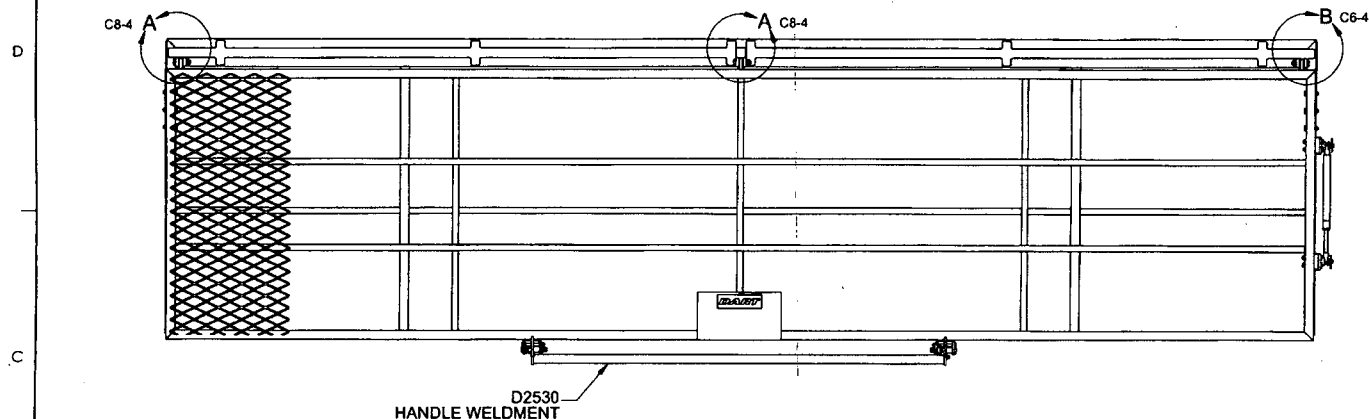
RELEASED
2013-08-16
MD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 57 lbs APPROX

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4030	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1



RELEASED
2013-08-16

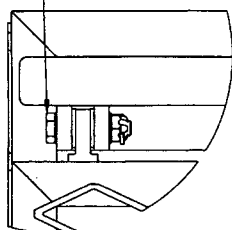
D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350) (SIMILAR)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D4030	REV. D
MFG. APPR.		TITLE	SHEET 3 OF 4
APPROVED		LONG BASKET ASSY (350)	SCALE
DE APPR.			NTS
DATE	13.07.18	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

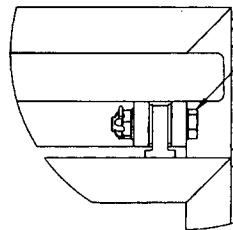
8 7 6 5 4 3 2 1

AN4-12 BOLT, MACHINE
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



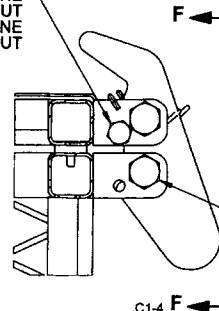
DETAIL A D8-3
D5-3

AN4-12 BOLT, MACHINE
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D3-3

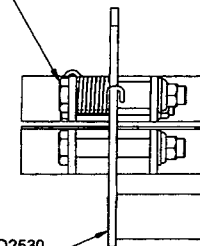
D4030-041: AN3-16A BOLT, MACHINE
MS21042L3 NUT
D4030-043: AN3-20A BOLT, MACHINE
MS21042L3 NUT



SECTION C-C B4-3
B6-3

D4030-041: AN5-17A BOLT, MACHINE
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT
D4030-043: AN5-21A BOLT, MACHINE
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT, MACHINE
NAS1149F0563P WASHER
MS21042L5 NUT



D2530
HANDLE WELDMENT
REF

VIEW F-F C3-4

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT, MACHINE
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-3





D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT, MACHINE
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-3

RELEASED
2013-08-16
MP

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CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4030	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
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